

Date: Monday, 18/09/2006 9:05:19 AM
 User: Linda Lacelle

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : SADDLE SPACER
Job Number : 28481	
Estimate Number : 10827	
P.O. Number : N/A	Part Number : D2877
This Issue : 18/09/2006 S.O. No. : N/A	Drawing Number : D2877 REV B
Prsht Rev. : NC	Project Number : N/A
First Issue : N/A Type : SMALL /MED FAB	Drawing Revision : B
Previous Run : 28481	Material : N/A
Written By : _____	Due Date : 25/09/2006 Qty: 120 Um: Each
Checked & Approved By : _____	
Comment : Est B 00.05.19 Added inspect level 8 EC	
Est C 06.04.26 Water jet EC	
Est Rev:D Now M6061-T6 06-06-23 JLM	
Est Rev:E Updated Thickness as per Rev B 06-09-18 JLM	

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	M6061T6S125	6061-T6 .125 Sheet
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Comment: Qty.: 0.5468 sf(s)/Unit Total: 65.6208 sf(s)

Material: 6061-T6 (QQ-A-250/8) 0.125" Thick

Batch: M101092

M 06 09 18

2.0	WATER JET	FLOW WATER JET
-----	-----------	----------------



Comment: FLOW WATER JET

1-Cut as per Dwg D2877

Dwg Rev: B

Prog Rev: B

M 06 09 18

(120)

2- Tumble

3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
-----	-----	--



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

M 06 09 18

(120)

4.0	QC8	SECOND CHECK
-----	-----	--------------



Comment: SECOND CHECK

J 06 05 26 (120) counted

Date: Monday, 18/09/2006 9:05:19 AM
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Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: SADDLE SPACER

Job Number: 28481

Part Number: D2877

Job Number:



Seq. #:

Machine Or Operation:

Description :

5.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

Tumble

Deburr any rough edges after tumbling

5.90 06/10/02

(120)

6.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

Y

06/10/24 x 120

coated

7.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

06/10/26

120

8.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: _____

57393

06/10/26

(120)

9.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

06/10/26

(120)

Job Completion



06/10/26

Date: Monday, 9/11/2006 3:43:50 PM
 User: Kim Johnston

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : SADDLE SPACER
Job Number : 28481	
Estimate Number : 10827	
P.O. Number :	Part Number : D2877
This Issue : 9/11/2006 S.O. No. :	Drawing Number : D2877 REV B
Prsht Rev. : NC	Project Number : N/A
First Issue : / / Type : SMALL /MED FAB	Drawing Revision : B
Previous Run : 26513	Material : NOTE:1 BLANK MAKES 4 PARTS
Written By :	Due Date : 9/22/2006 Qty: 120 Um: Each
Checked & Approved By :	
Comment :	

Est B 00.05.19 Added inspect level 8 EC
 Est C 06.04.26 Water jet EC
 Est Rev:D Now M6061-T6 06-06-23 JLM

Additional Product

Job Number:



Seq. #:

Machine Or Operation:

Description :

1.0

M6061T6S100

6061-T6 .100 Sheet



Comment: Qty.: 0.5468 sf(s)/Unit Total : 66.6208 sf(s)
 Material: 6061-T6 (QC-A-250/8) 0.100" Thick
 Batch: _____

2.0

WATER JET

FLOW WATER JET



Comment: FLOW WATER JET
 1-Cut as per Dwg D2877
 Dwg Rev: _____
 Prog Rev: _____

2- Tumble

3.0

QC2

INSPECT PARTS AS THEY COME OFF MACHINE



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

4.0

QC8

SECOND CHECK



Comment: SECOND CHECK

5.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1
 Tumble
 Deburr any rough edges after tumbling

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Monday, 9/11/2006 3:43:50 PM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: SADDLE SPACER

Job Number: 28481

Part Number: D2877

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

7.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

8.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: _____

9.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



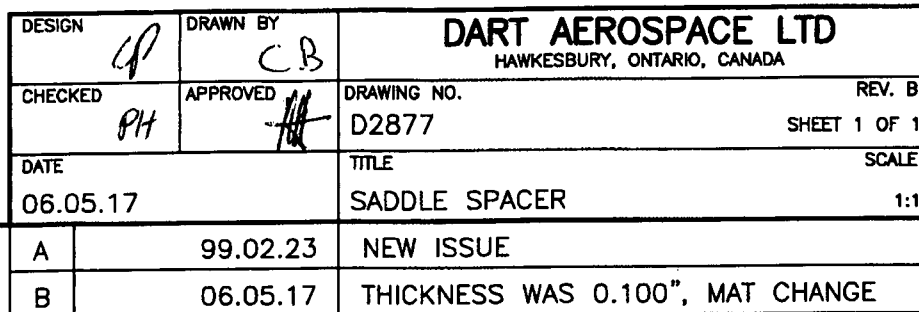
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

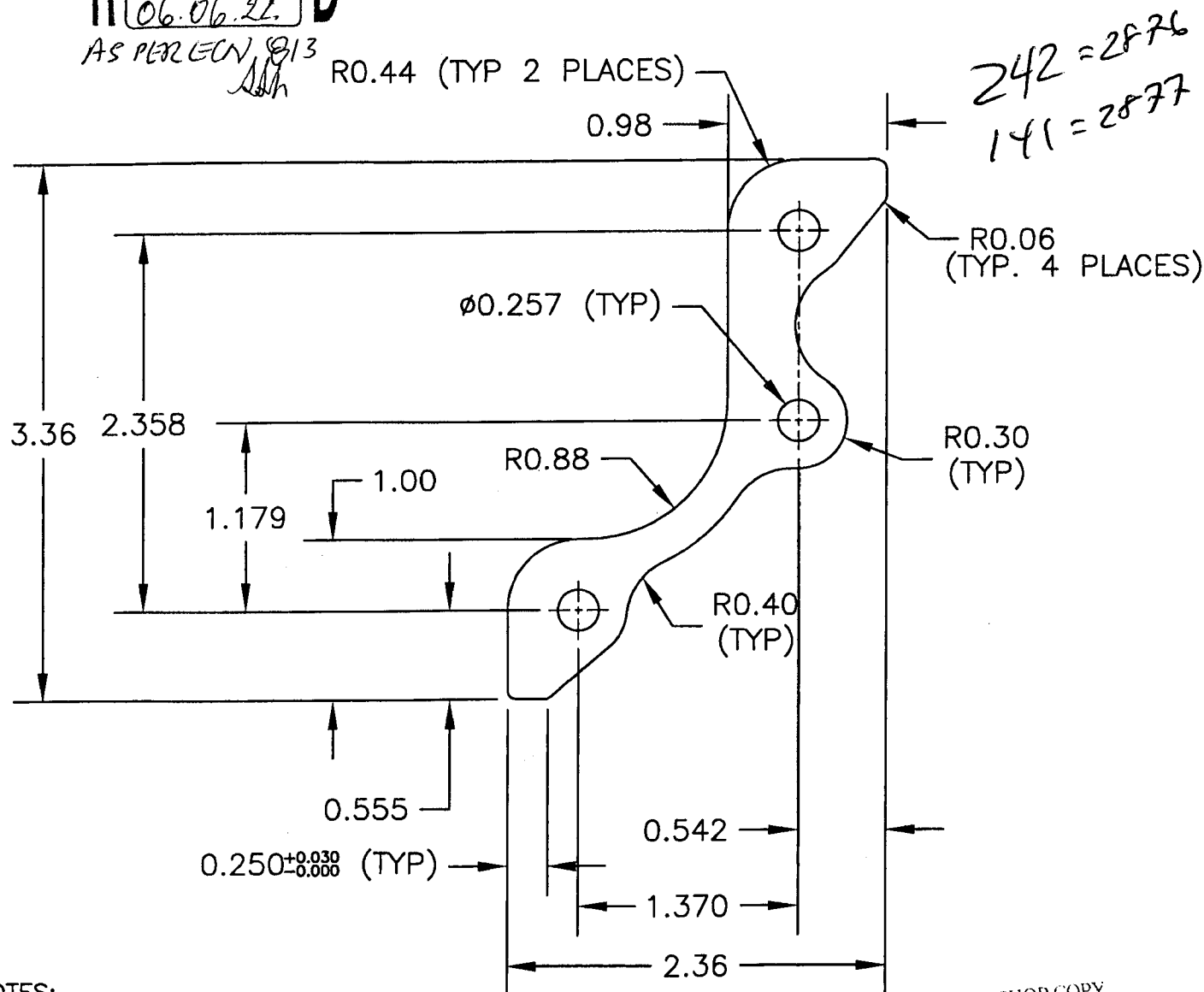
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



RELEASED
06.06.21

AS PER ECN, §13



NOTES:

- 1) MATERIAL: 6061-T6 ALUMINUM SHEET (QQ-A-250/11) 0.125" THICK
(REF DART SPEC M6061T6S.125)
OR
5052-H32/H34 ALUMINUM SHEET (QQ-A-250/8) 0.125" THICK
(REF DART SPEC M5052H32S.125)
- 2) FINISH: ACID ETCH AND ALODINE PER DART QSI 005 4.1
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) BREAK ALL SHARP EDGES 0.010 TO 0.020
- 5) ALL DIMENSIONS ARE IN INCHES

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 WITHOUT NOTICE
 WORK ORDER
 NO. 28481

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